

Date: Monday, 7/9/2007 11:41:42 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR ARM LONG (S-76)
Job Number : 33329	
Estimate Number : 11893	
P.O. Number : N/A	Part Number : D2261
This Issue : 7/9/2007 S.O. No. : N/A	Drawing Number : D2261 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A1
Previous Run : 33053	Material : N/A
Written By : <u>                    </u>	Due Date : 7/30/2007
Checked & Approved By : <u>                    </u>	Qty: 2 Um: Each
Comment : Est: D 02.04.15 Added dwg Rev.A1 NG	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304TR0500W035

304 RD Tube .500 x .035W



Comment: Qty.: 3.1281 f(s)/Unit Total: 6.2561 f(s)

 Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall  
 (M304TR0500W035)

Batch No:

M1048800

FF 07/08/14

2

2.0

BRAKE NC

NC BRAKE



Comment: BRAKE NC

Punch tube 304/316 with 2B finish

Form as per dwg D2261

Debur

FF 07/08/14

FF 07-08-22

2

2

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

A12/03 (42)

4.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M8 07-12-03

(X3)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 07/12/04 (2)

6.0

D2022101

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

33985

C 7/12/4 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM LONG (S-76)

Job Number: 33329

Part Number: D2261

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 D2022-101 Spacer

7.0

A1449

Grommet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Grommet

Pick:

Qty Part Number Description Batch

2 A1449 Grommet M1487

CU 7/12/04 (2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x2

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2261

mul 07/12/04

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 7/12/04 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

6 7/12/05 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

207/12/04

Job Completion



U 07-12-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

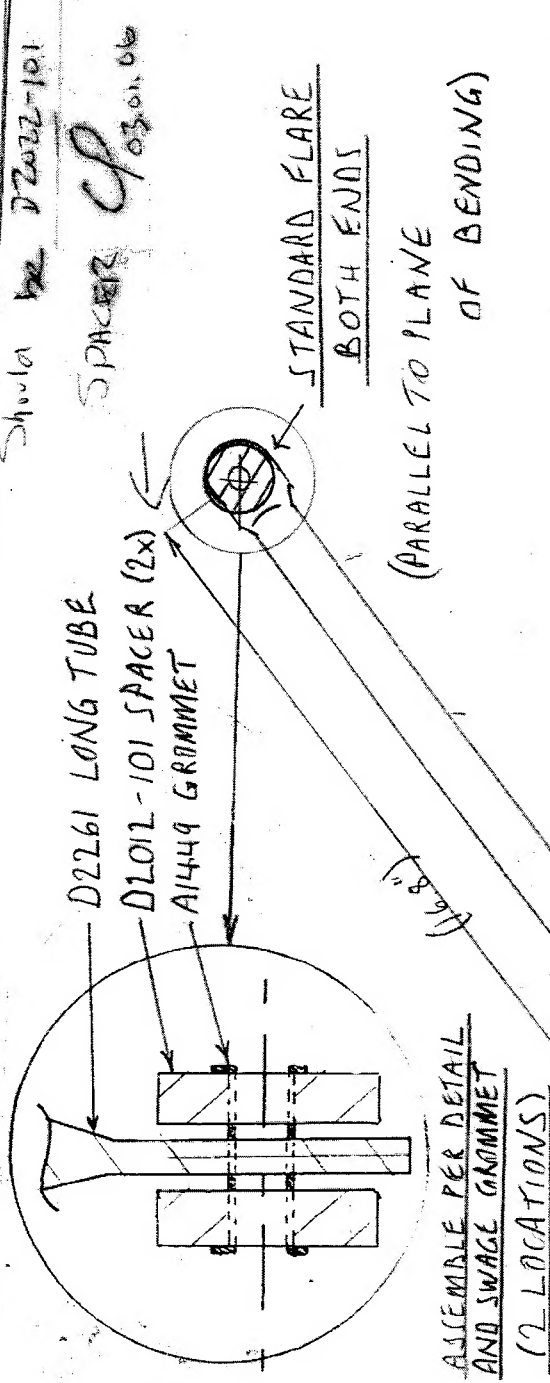
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DRAWN M. Cohen.	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA
DESIGN	DRAWING NO. 02261
	REV. A
	SHEET 1 OF 1
Aug 10/94	TITLE LONG TUBE
A1	ADD FINISH



MATL: 304 SS 1/2" OD x .035" WALL TUBE  
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7)  
PER DART Q51 QMS 4.3 (A1)

PROCEDURE:

1. TOTAL TUBE LENGTH = 35.75"
2. STANDARD FLARE BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.
  - I] FEED THRU 11", BEND 90°
  - II] FEED THRU 19 3/4" (TOTAL), BEND 60°

